Work Order I Friday, October 24, 2				*125	5905	*						Page 1	
Revision ID:	92-3			Accept	*N:	ลกก	<b>040</b>	100	<b>)</b> * s	etup Star Sto		S1*	
Required Date: 11/2	27/14 <b>Star</b>	t Qty: 400.00				t Item I tomer:	D:			310	* *N;	S2*	
Reference: Approvals: Pro	ocess Plan:	M	Date: <u>  \                                  </u>	Tooling:  SPC (Y/N):			ate:		R	un Star Sto <sub>l</sub>	^ <b> \</b>	R1* R2*	
Sequence ID/ Work Center ID		ation ription		Set Up/ Run Hours	To	ol ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp	_
Draw Nbr	Revision 1	Nbr											
D3492	Е											DAS	-
100 <b>*1 \\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\</b>	Hardi	nge CNC LATHE	SMALL	0.00	4	AS  0  89			404	Ø		37 9-89 /4/.	11.03
Hardinge CNC Lathe Sma	ıll		oer Folio FA632 & Dwg I E MA	D3492		/u/u							
110	QC2-	Inspect parts off	machine FAI/FAIB	0.00					Heat			DAS <b>37</b>	
*110* QC Quality Control		Memo		0.00					409	_Ø_		9-89 /4.,	1.03
120	QC8-	Inspect parts - sec	cond check	0.00	λ.		١		/1541	1		DAS 08	
*120*		Memo		0.00	12.0	14/11	illii		404	_Ψ_		9-8:	

Quality Control

DQA:			Date:										A DT
						<b>WORK ORDER NON</b>	I-C	ONFO	RMANCE / U	PDATE			AFROSPACE
QA Closed:			Date:						-		ork Order up	date only	72.037.402
Work Ord	er:					DISPOSITION				AGAINST DI	PARTMENT	/PROCESS	
Part I			-			Rework Scrap Use-as-is Suspected Unapproved	-		Skid-tube  Machining  noforming  Large Fab	Crosstube Small Fab Finishing Composite		Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
	•••					- Suspected Onapproved	J		raige rab	composite		Jupplier	
Root Cause		Date	Step	Qty	Desc	ription of work order update or non-conformance		Initial nief Eng	i	tion ription	Sign & Date	Verificatio	n QC Inspector
Design		Dute	Step	Qty		or non comormance	10,	ner Eng	Desc	прион	Date	Vermeation	de mapector
Doc/Data Equip/Tooling													
Handling/Pre													
Material	<u> </u>												
Operator	-												
Offset/Setup	┝				•		1						
Process	-					• *	1						
Supplier	<del> </del>												75.
Training Transport	<del> </del>						1						The second secon
Unapproved	}												
Опарргочес	l		<u> </u>				FΔ	LILT CAT	L TEGORY ·				
Landi	ng (	iear				General	10	OLI CA	TEGORI -				. v
		Bending				Bend		leolio/P	Program		Outside Dim	ensions	Pressure/Forced
		Centre No	ot Concen	itric		BOM/Route		Grain			Over/Under		Set-up
		Cracks				Broken/Damage/Defect		Hardwa	ire		Part Incorred		Temperature/Cure
		Crimp/Kir	nk/Ripple	/Wave		Burrs		-{	ion Incomplete/U	ngualified	Part Lost/Mi		Weld
A16		Cuffs	, , , ,			Contamination		-	ions Incomplete/	· · —	Part Moved		Wrong Stock Pulled
3.5'		Crushing				Countersink	H	4	ned/off center		Positioned V	Vrong	<u> </u>
·		Heat Trea	at			Cut Too Short		Mislabe		-	Power Loss/		Other
		Inspection	n Strip in	Tube		Drawing	Г	Misread			<b>-</b>	<del>-</del>	
		Marks/Ch	natter			Drill Holes		Off-set					
		Turning S	equence			Finish		Out of (	Calibration				
		Wave/Tw	ist in Tub	е		Fit/Function		Out of 9	Sequence				

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Work	Order ID	125905

# \*125905\*

Page 2

Friday, October 24, 2014 11:12:31 AM \*N900040100\* D3492-3 Accept Setup Start Item ID: **Revision ID:** Stop Plug **Item Name:** \*400\* **Start Date:** 10/27/14 **Start Oty: 400.00 Cust Item ID:** Required Date: 11/28/14 Reg'd Oty: 400.00 \*400\* **Customer:** Reference: Run Start Process Plan: Date: **Tooling:** Date: Approvals: Stop SPC (Y/N): QC: Date: Date: Tool # Plan Reject Reject Sequence ID/ Operation Set Up/ Tool ID Accept Insp. **Description** Code Qty Qty Number Stamp **Work Center ID Run Hours** Chemical Conversion Coat per QSI005 4.1 130 0.00 HOH & M-11-26 \*130\* 0.00 HandFinish Memo Hand Finishing White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum 0.00 140 \*140\* 0.00 Powdercoat (Flat End Only) Powder Coating START TIME: OVEN TEMPERATUR FINISH TIME: DAS 150 QC3- Inspect Part Finish 0.00 38 \*150\* 0.00 QC Memo DEC 0 1 2014 Quality Control

DQA:			Date:			WORK ORDER NON	c	SNEOT		IDDATE				DART
QA Closed:			Date:			WORK ORDER NON	-00	JNFUI	RIVIAINCE / I	UPDATE	W	ork Order up	odate only	AEROSPACE
Work Orde	or.			٠		DISPOSITION				AGAINST	DE	PARTMENT	/PROCESS	<u> </u>
WORK OTAL					-	Rework	1		Skid-tube	Crosstube	Γ	1	Water Jet	Engineering
Part N	No.					Scrap	1 1		Machining	Small Fab	-	Pro	d. Eng. Coor.	Quality
	_					Use-as-is			noforming	Finishing	-	-	re/Packaging	Other
NCR N	No					Suspected Unapproved			Large Fab	Composite	-	] '	Supplier	
Root					Desci	ription of work order update	Π	nitial	А	ction	-	Sign &		
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Des	cription		Date	Verification	QC Inspector
Design														
Doc/Data														
Equip/Tooling	Щ													
Handling/Pre														
Material			,											
Operator	Ш													
Offset/Setup														
Process														
Supplier	Щ						1 .							
Training	$\Box$												•	
Transport	Щ <u>.,</u> ,	* . •,							·					
Unapproved		` .					<u> </u>			•	•			
							FAI	ULT CAT	regory					
Landi:						General		le - 1: - 75			_	1		٦, ,,
		nding	+ Camaan		-	Bend BOM/Route		1	rogram	•	-	Outside Dim	<b>⊢</b>	Pressure/Forced
	—	ntre No acks	t Concer	itric		BOM/Route		Grain			$\vdash$	Over/Under	<b> </b>	Set-up
*.4	—		k/Ripple	Maua		Broken/Damage/Defect		Hardwa		l to much lift and	$\vdash$	Part Incorred	_	Temperature/Cure
	_	ffs	k) vibbie	/ vv ave		Burrs Contamination	$\vdash$	1	ion Incomplete/		$\vdash$	Part Lost/Mi Part Moved		Weld
		ushing			<b>——</b>	Countersink	-	ł	ions Incomplete		$\vdash$	-		Wrong Stock Pulled
		at Trea	t		-	Cut Too Short	-	Mislabe	ned/off center	ı	$\vdash$	Positioned W Power Loss/S		Other
			Strip in	Tube	-	Drawing	$\vdash$	Misread				Trower rossy:	ourge	Tother
	_	arks/Ch	· .	iune	$\vdash$	Drill Holes	-	Off-set	a .					
			equence		-	Finish	$\vdash$	ł	Calibration					
	_		ist in Tub	ie.	-	Fit/Function	-	1 .	Sequence				<u>.</u>	<u></u>

H:/FORMS/Quality Assurance\approved QA/NCRWO RevH

Work Orde Friday, October				*125	5905*					Page 3				
Item ID: Revision ID: Item Name:	D3492-3			Accept	*N900	<b>04</b> 0	100	)* <sup>s</sup>	Setup	Start Stop		S1* S2*		
Start Date: Required Date: Reference:	10/27/14 11/28/14	<b>Start Qty:</b> 400.00 <b>Req'd Qty:</b> 400.00	*400 *400	_	Cust Item I Customer:	D:				<b>G</b>				
Approvals:	Process Pla	ın:	Date:	Tooling:	Da	ate:		F	Run	Start	*N	R1*		
	QC:		Date:	SPC (Y/N):	D:	ate:				Stop	*N	R2*		
Sequence ID/ Work Center II	D	Operation Description Identify as per dwg & Stoo	k Location: ∏-∝	Set Up/ Run Hours  0.00	Tool ID	Tool#	Plan Code	Accept Qty	Rej Qty		Reject Number	Insp. Stamp		
*160* Packaging Packaging		Мето		0.00				401	4	>		4/4/21		

0.00

0.00

QC21- Final Inspection - Work Order Release

Memo

170

\*170\*

Quality Control

14/12/2. At

DQA:			Date:			WORK ORDER NON	I C	ONEO	DNAANCE / LIDDA:	TC			DART
QA Closed:			Date:			WORK ORDER NON	1-C1	JINFUI	RIVIANCE / UPDA		ork Order up	date only	AEROSPACE
Work Ord	er:	-				DISPOSITION			A	GAINST DE	PARTMENT	/PROCESS	
Part   NCR						Rework Scrap Use-as-is Suspected Unapproved			Machining Sm noforming Fi	osstube nall Fab inishing mposite		Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root					Desc	ription of work order update		Initial	Action		Sign &		
Cause		Date	Step	Qty		or non-conformance	Cł	nief Eng	Description	n	Date	Verification	QC Inspector
Design Doc/Data Equip/Tooling Handling/Pre Material Operator Offset/Setup Process Supplier Training Transport Unapproved									·				
							FA	ULT CA	regory				
Landi	ng (	Gear				General							
		Bending Centre No Cracks Crimp/Kir Cuffs Crushing Heat Trea Inspection	nk/Ripple ut n Strip in	/Wave		Bend BOM/Route Broken/Damage/Defect Burrs Contamination Countersink Cut Too Short Drawing		Grain Hardwa Inspect Instruct Misalig Mislabe	ion Incomplete/Unqualif tions Incomplete/Unclear gned/off center eled	fied	Outside Dim Over/Under Part Incorred Part Lost/Mi Part Moved Positioned W Power Loss/S	tolerance ct ssing	Pressure/Forced Set-up Temperature/Cure Weld Wrong Stock Pulled Other
	_	Marks/Ch			-	Drill Holes	-	Off-set					
		Turning S Wave/Tw		e		Finish Fit/Function	-	1	Calibration Sequence				

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**Picklist Print** 

Friday, October 24, 2014 11:12:34 AM

Work Order ID: 125905

\*125905\*

Parent Item:

D3492-3

\*D3492-3\*

Parent Item Name: Plug

**Start Date:** 10/27/14

Required Date: 11/28/14

Page 1

Start Qty: 400.00

Required Qty: 400.00

**Comments:** 

IPP Rev:A 11.04.19 per dwg revC DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Primary Item Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6R0.750		Purchased	No		100	f	53.4941	0.06	26		DAS <b>37</b>	
*M6061T6	SR0 750	*						**			9-89	14.11-03

6061-T6 Round Bar .750"

Location	Loc Qty	Loc Code	
MAT012	53.494052		
m126852	3.494052		
m130043	2		
m130527	48		
M130745			21

L6,

DQA:			Date:										TRAC
QA Closed:			Date:			WORK ORDER NON	-C(	ONFO	RMANCE / U		Vork Order u	pdate only	AEROSPACE
		,				DISPOSITION				· •••	EPARTMENT	· · · · · · · · · · · · · · · · · · ·	
Work Orde	er: _					5151 55111514	.			AGAMSTE	—	, i ilocess	_
						Rework			Skid-tube	Crosstube		Water Jet	Engineering
Part N	۷o					Scrap		ŀ	Machining	Small Fab	<b>_</b>	d. Eng. Coor.	Quality
						Use-as-is		I	noforming	Finishing	Rec/Sto	re/Packaging	Other
NCR N	No	,				Suspected Unapproved	]		Large Fab	Composite		Supplier	
Root					Descr	ription of work order update		Initial	Ac	tion	Sign &		
Cause		Date	Step	Qty		or non-conformance	Ch	nief Eng	Desc	ription	Date	Verification	QC Inspector
Design :													
Doc/Data													
Equip/Tooling													
Handling/Pre	Ш												
Material									-				
Operator	Ш												
Offset/Setup													
Process													
Supplier											1		
Training											İ		
Transport	Ш												
Unapproved													
							FA	ULT CAT	TEGORY				
Landi	ng Ge	ear				General		_					<u></u>
	╚	Bending				Bend		Folio/P	rogram		Outside Din	nensions	Pressure/Forced
	Щ	Centre No	t Concer	ntric		BOM/Route		Grain			Over/Under	tolerance	Set-up
		Cracks				Broken/Damage/Defect		Hardwa	re		Part Incorre	ct	Temperature/Cure
		Crimp/Kin	k/Ripple	/Wave		Burrs		Inspecti	on Incomplete/U	Inqualified	Part Lost/M	issing	Weld
		Cuffs				Contamination		Instruct	ions Incomplete/	'Unclear	Part Moved		Wrong Stock Pulled
		Crushing				Countersink		Misalig	ned/off center	Γ	Positioned \		<del></del>
		leat Trea	t.			Cut Too Short		Mislabe	eled	Γ	Power Loss,	'Surge	Other
		nspection	Strip in	Tube		Drawing		Misread	i	_			
		Marks/Ch	atter			Drill Holes		Off-set					
	ד	Turning Se	equence			Finish		Out of 0	Calibration				
	$\bigsqcup$ $ackslash$	Nave/Tw	ist in Tub	e		Fit/Function		Out of S	Sequence		<del> </del>		

H:/FORMS/Quality Assurance\approved QA/NCRWO RevH

DART AEROSPACE LTD	Work Order:	125905
Description: Plug	Part Number:	D3492-3
Inspection Dwg: D3492 Rev: E		Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.750	+/-0.010	.743	/		DRIG	8"VERN
Ø0.582	+0.000/-0.002	<sub>2</sub> 5815	~		3 1	11
0.045	+0.000/-0.002	.0445				• • •
0.060	+/-0.005	. 060	س		11	**
0.060	+/-0.005	5058	/		'1	
0.500	+/-0.010	,500	_		11	10.
0.090	+0.000/-0.002	.089	/		18	, t
	·					
_	14					
						:
-						
	DAS	L			l	L.,

DAS Dating and American						07	
Measured by: 9-89 Audited by: 12.6 Preliminary Approval:	iry Approval:	Preliminary Approval:	DAS OS	٥. لا	Audited by:	9-89	Measured by:
Date: 14(11.073 Date: 14(11/11 9-89 Date:	Date:	·	1	14/11/11	Date:	14.11.03	Date:

Rev	Date	Change	Revised by	Approved
Α	06.07.07	New Issue P/O D3492-043	KJ/JLM	
В	06.10.16	Ø0.750 was Ø0.625	KJ/JLM	<u> </u>
С	08.09.04	Tolerance revised for Ø0.750	KJ/DD	
D	11.06.21	Dwg Rev updated	KJ	
Ē	12.10.26	Tolerance revised for Ø0.582	. KJ <u>)</u> Λ	
F	14.01.21	Dwg Rev updated	KJ 🦮	IM.

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D3492-XX PLUG (SEE TABLE)--NAS1611 O-RING (SEE TABLE)

**D3492-XXX PLUG PARTS LIST** 

	DO TO LOCAL TO LIGHT									
QTY -041	QTY -043	QTY -045	QTY -047	QTY -049	QTY -051	QTY -053	QTY -055	PART NUMBER	DESCRIPTION	
Х								D3492-041	PLUG ASSEMBLY	7
	х							D3492-043	PLUG ASSEMBLY	7
		x						D3492-045	PLUG ASSEMBLY	7
			X					D3492-047	PLUG ASSEMBLY	7
	L			Х				D3492-049	PLUG ASSEMBLY	7
					Х			D3492-051	PLUG ASSEMBLY	7
						X		D3492-053	PLUG ASSEMBLY	7
							X	D3492-055	PLUG ASSEMBLY	
1								D3492-1	PLUG	
	1							D3492-3	PLUG	
		1						D3492-5	PLUG	
			1					D3492-7	PLUG	
				1				D3492-9	PLUG	
					1			D3492-11	PLUG	7
						_ 1 ]		D3492-13	PLUG	1
							1	D3492-15	PLUG	
		1						NAS1611-005	O-RING	4
			1					NAS1611-007	O-RING	-
1	-	-	'					NAS1611-010	O-RING	
						1		NAS1611-010		4
	1					_'		NAS1611-012	O-RING	4
	-								O-RING	4
					1		1	NAS1611-015	O-RING	╛
				1				NAS1611-016	O-RING	1

NOTES: 1) O-RING: POSSIBLE SUPPLIER P/N: NAS1611-XXX OR PARKER 2-XXX

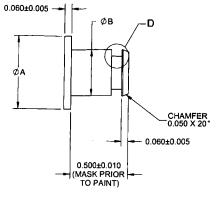
DESIG	N DU	DART AFROCE		
REV.	DESCRIPTION	BY	DATE	
Α	NEW ISSUE	PH	06.01.04	
В	ADD -047; UPDATE DIM /	A FOR -045	PH	06.05.11
С	ADD -049/-051/-053, CHA	PH 07.10.		
D	INCORPORATED DEO D: WAS 0.055. (SEE CAR11-	AJS	11.05.24	
E	ADD -055 PLUG ASSY &	AP	13.08.08	

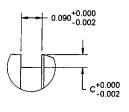
DESIGN PH		DART AEROSPACE LTD				
DRAWN	AP	HAWKESBURY, ONTARIO, CANADA				
CHECKED ASS		DRAWING NO.	REV. E			
MFG. APPR.		D3492	SHEET 1 OF 2			
APPROVED	149	TITLE	SCALE			
DE APPR.	-#	PLUG	NTS			
DATE 13.0	8.08	COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IN PRIVATE MY COMPENSION ON THE CURES SOMETION THAT IT IS NOT TO BE USED FOR MY PURPOSE OR COMED ON COMMUNICATED TO ANY OTHER PERSON WITHOUT				

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POWDER COAT THESE FACES ONLY PER NOTE 2

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**DETAIL D** 

### D3492-XX PLUG

## **D3492-XX PLUG MACHINING DETAILS**

P/N	A	В	С	MATERIAL SPEC	
D3492-1	0.625	0.394	0.050	M6061T6R0.625	
D3492-3	0.750	0.582	0.045	M6061T6R0.750	
D3492-5	0.375	0.188	0.045	M6061T6R0.375	
D3492-7	0.500	0.270	0.045	M6061T6R0.500	
D3492-9	0.938	0.750	0.045	M6061T6R1.000	
D3492-11	0.850	0.664	0.045	M6061T6R0.875	
D3492-13	0.750	0.510	0.045	M6061T6R0.750	
D3492-15	0.850	0.640	0.050	M6061T6R0.875	



D

NOTES:
1) MATERIAL: ALUMINUM 5052-H32 OR 6061-T6 OR 1100-0 PER QQ-A-225/7 (5052) OR QQ-A-225/8 (6061) OR QQ-A-200/8 (6061) OR QQ-A-225/1 (1100) (REF. DART MATERIAL SPEC M6061T6R0.000)
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT WHITE GLOSS (4.3.5.1) PER DART QSI 005 4.3
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: N/A

DESIGN PH		DART AEROSPACE LTD				
DRAWN	AP	HAWKESBURY,	HAWKESBURY, ONTARIO, CANADA			
CHECKED	155	DRAWING NO.	REV. E			
MFG. APPR.	77	D3492	SHEET 2 OF 2			
APPROVED	100	TITLE	SCALE			
DE APPR.		PLUG	4:1			
DATE 13.0	08.08	THE DOORMEN IS NOW THAT OF 2007 BY DART AEROSPACE LYD THE DOORMEN IS NOW COMPRETIFUL AND IS SUPPLED ON THE EXPRESS CONCRITION THAT IS NOT TO BE USED FOR ANY FURFORCE OR COMPLOSED ON COMMANDATION TO NAY OTHER PERSON WITHOUT				

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